

Stop July 15th

# Work Order ID 60158

June 28, 2010 11:31:16 AM



Page 1

Item ID: D119-646-451  
Revision ID:  
Item Name: Wearplates, LH, OEM

Accept



Setup

Start



Stop



Start Date: 6/28/10 Start Qty: 1.00  
Required Date: 7/07/10 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: CL Date: 10/6/28 Tooling:  
QC: Date: SPC (Y/N):

Date:  
Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9526

A

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy blue file, & type labels as per PPP D119-646-451/ DSI 9526 CHG 001

Scoloric

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-7-9 SP (13)

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Scoloric

(X)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 60158**

June 28, 2010 11:31:16 AM

Page 2

Item ID: D119-646-451

Accept

Setup

Start

Revision ID:

Stop

Item Name: Wearplates, LH, OEM

Start Date: 6/28/10 Start Qty: 1.00

Cust Item ID:

Required Date: 7/07/10 Req'd Qty: 1.00

Customer:

Reference:



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

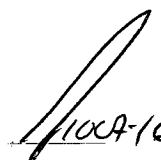
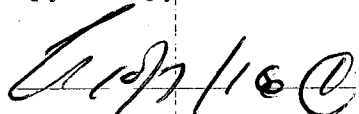
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-646-451/ DSI 9526 Location: _____ PPP rev: _____								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

MF  
10-7-16

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 28, 2010 11:31:16 AM

Page 1/2

Work Order ID: 60158

Parent Item: D119-646-451

Parent Item Name: Wearplates, LH, OEM

Start Date: 6/28/10

Required Date: 7/07/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.25 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4132-041 Wearplate, LH Fwd		Manufactured	No			110	Each	0.0000	1	1			
D4133-041 Wearplate, Mid		Manufactured	No			110	Each	0.0000	1	1			
D4134-041 Wearplate, LH Aft		Manufactured	No			110	Each	0.0000	1	1			
D4135-1 Wearpad		Manufactured	No			110	Each	0.0000	3	3			
AELS-1032-130 INSERT		Purchased	No			110	Each	0.0000	20	20			
AELS-1032-225 INSERT		Purchased	No			110	Each	0.0000	12	12			

ALSY-1032-225

60162

60165

60166

60167

M1114707 107-958

M1110708 107-958

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 28, 2010 11:31:16 AM

Page 2 / 2

Work Order ID: 60158



Parent Item: D119-646-451



Parent Item Name: Wearplates, LH, OEM

Start Date: 6/28/10

Required Date: 7/07/10

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased No

110 Each

1,232.000

54 54



Bolt



10-7-98

## Location

## Loc Qty

## Loc Code

ST350	1217	
114330	11	
114523	18	
114808	188	
115015	1000	
ST351	15	
113121	10	
114108	5	

4

75

5

54

NAS1149C0332R

Purchased No

110 Each

5,120.000

54



Washer



10-7-98 (10)

## Location

## Loc Qty

## Loc Code

ST297	5120	
113524	10	
113737	150	
114341	36	
115000	4924	

54

June 28, 2010 11:31:16 AM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Stop July 15<sup>th</sup>

# Work Order ID 60158



Page 1

June 28, 2010 11:31:16 AM

Item ID: D119-646-451

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplates, LH, OEM

Start Date: 6/28/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/07/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *CZ*

Date: 10/6/28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9526

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file, & type labels as per PPP D119-646-451/ DSI 9526 CHG 001

*CZ 10/7/8*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

REFERENCE ONLY

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

# REFERENCE ONLY

## PARTS LIST

QTY -451	QTY -452	PART NUMBER	DESCRIPTION
X		D119-646-451	WEARPLATE KIT, OEM LH
	X	D119-646-452	WEARPLATE KIT, OEM RH
1		D4132-041	WEARPLATE, FWD LH
1		*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4132-042	WEARPLATE, FWD RH
	1	*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
1	1	D4133-041	WEARPLATE, MID
1	1	*D4133-3	GASKET (BONDED WITH 3M 1300/1300L)
1		D4134-041	WEARPLATE, AFT
1		*D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4134-042	WEARPLATE, AFT
	1	D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
3	3	D4135-1	WEARPAD
20	20	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
54	54	AN3C5A	BOLT
54	54	NAS1149CO332R	WASHER

\* denotes that part is included in assembly above

## WEIGHT AND BALANCE

The following weight and balance information is for the Dart D119-646-451/-452 kits only. The weight and balance of the wearplates removed are the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D119-646-451	10.8 lb	117.7 in	1271 in lb	-39.4 in	-426 in lb
WEARPLATE KIT, LH	4.9 kg	2.99 m	14.7 m kg	-1.00 m	-4.9 m kg
D119-646-452	10.8 lb	117.7 in	1271 in lb	+39.4 in	+426 in lb
WEARPLATE KIT, RH	4.9 kg	2.99 m	14.7 m kg	+1.00 m	+4.9 m kg

DESIGN	90	<b>DART AEROSPACE USA, INC</b>	
DRAWN	90	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9526	SHEET 2 OF 3
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	OEM WEARPLATE KIT	NTS
DATE	10.06.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	